



Dart Aerospace Ltd.
1270 Aberdeen St
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D2940-1**Job Sheet 215057****Part No:** D2940-1**Job Qty:** 6 pcs**Part Name:** Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/5/20**Job Tracking No:****Due Date:** 11/23/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG D2940 REV D IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G 11.08.04 as per dwg rev.C DD verf:EC/IPP Rev.H 19.10.01 DWG revision (ECN 19-829) DP Verify DD

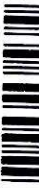
Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	11/21/20		2.00	13.95	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		✓ 20-11-19
110	QC 2	6 pcs	11/21/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		✓ 20-11-19
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

DART Aerospace Ltd.
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Container No: S314313



Part: D2940-1

Job No: 215057

Serial No/Batch: S314313

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/19/20

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120	QC 8	6 pcs	11/21/20	0.00	0.00	QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
						QC 8 - 12	
						QC 8 - 14	7.20/11/22
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
130	Crosstubes - 2 - B4B	6 pcs	11/23/20	0.00	0.75	QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
140	QC 5	6 pcs	11/23/20	0.00	0.00	QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
						Crosstubes - 1 - B4B	
						Crosstubes - 2 - B4B	DAG
						Crosstubes - 3 - B4B	41 NOV 2 5 2020
						Crosstubes - 4 - B4B	3.0
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	NHV 26 2020 ^{DAS} 40
					QC 5 - 61	9-89
					QC 5 - 81	
					QC 5 - 82	
170	Packaging 3-1 - Stock - B4B 6 pcs	11/23/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	DAS
					Packaging 3 - 22 - B4B	41 NHV 26 2020
					Packaging 3 - 23 - B4B	9-89
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
180	QC 21 - SA 6 pcs	11/23/20	0.00	0.00	QC 21 - SA - 21	21 NHV 26 2020
					QC 21 - SA - 70	9-89
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 110 - (QC8- Inspect parts - second check)

120 - (QC8- Inspect parts - second check)

130 - Per note 9 on page 1 of dwg D2940, Prep inner concave surface of support and use DT10658 apply 3M Scotch-

Weld as per dwg. 5206979 exp 8/21

140 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: L6051) LOCATION : L6052

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5244752

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK081	3	6	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
2	3.250 Support	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
3	3.250 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
4	3.250 Support	3.510Inches	+ 0.020 - 0.000	3.530 3.510	
5	3.250 Support	1.633Inches	+ 0.040 - 0.000	1.673 1.633	
6	3.250 Support	1.493Inches	+ 0.020 - 0.000	1.513 1.493	
7	3.250 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
8	3.250 Support	0.188Inches	+ 0.005 - 0.000	0.193 0.188	
9	3.250 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
10	3.250 Support	2.518Inches	+ 0.020 - 0.000	2.538 2.518	
11	3.250 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
12	3.250 Support	0.010Inches	+ 0.010 - 0.000	0.020 0.010	
13	3.250 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
14	3.250 Support	0.350Inches	+ 0.100 - 0.000	0.450 0.350	
15	3.250 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
16	3.250 Support	0.150Inches	+ 0.020 - 0.000	0.170 0.150	
17	3.250 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053	
18	3.250 Support	101.640Inches	+ 4.000 - 0.000	105.640 101.640	
19	3.250 Support	0.260Inches	+ 0.007 - 0.000	0.267 0.260	
20	3.250 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053	
21	3.250 Support	4.118Inches	+ 0.020 - 0.000	4.138 4.118	

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DART AEROSPACE LTD		Work Order: 215057
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.140	0.190		-160	-161	-160	-160	-160
AB	0.040	0.060		-048	-048	-048	-048	-048
AC	Ø0.187	Ø0.193		-189	-189	-189	-189	-189
AD	Ø0.260	Ø0.267		-261	-261	-261	-261	-261
AE	0.143	0.163		-153	-156	-156	-155	-155
AF	1.485	1.525		1.501	1.499	1.498	1.499	1.499
AG	3.510	3.530		3.523	3.525	3.520	3.522	3.522
AH	0.350	0.450		-380	-380	-380	-380	-380
AI	4.930	4.990		4.958	4.958	4.957	4.957	4.957
AJ	0.140	0.180		-160	-160	-160	-160	-160
AK	0.140	0.180		-162	-163	-163	-162	-162
AL	2.322	2.342		2.332	2.332	2.330	2.330	2.330
AM	0.090	0.110		-099	-099	-099	-099	-099
AN	0.040	0.060		-052	-048	-055	-051	-054
AO	0.140	0.160		-148	-144	-147	-148	-145
AP	R0.240	R0.260		-250	-250	-250	-250	-250
AQ	R0.053	R0.073		-063	-063	-063	-063	-063
AR	R0.053	R0.073		-063	-063	-063	-063	-063
AS	R0.240	R0.260		-250	-250	-250	-250	-250
AT	R0.470	R0.530		-500	-500	-500	-500	-500
AU	R0.920	R0.980		-950	-950	-950	-950	-950
AV								
AW								
Accept/Reject								

Measured by: JL

Date: 20-11-16

Audited by: [Signature]

Date: 20/11/22

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MC [Signature]	DP

DART AEROSPACE LTD		Work Order: 215057
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

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AB	0.040	0.060		-048				
AC	Ø0.187	Ø0.193		-189				
AD	Ø0.260	Ø0.267		-261				
AE	0.143	0.163		-154				
AF	1.485	1.525		1.499				
AG	3.510	3.530		3.523				
AH	0.350	0.450		-380				
AI	4.930	4.990		4.957				
AJ	0.140	0.180		-160				
AK	0.140	0.180		-162				
AL	2.322	2.342		2.336				
AM	0.090	0.110		-099				
AN	0.040	0.060		-052				
AO	0.140	0.160		-144				
AP	R0.240	R0.260		-250				
AQ	R0.053	R0.073		-063				
AR	R0.053	R0.073		-063				
AS	R0.240	R0.260		-250				
AT	R0.470	R0.530		-500				
AU	R0.920	R0.980		-950				
AV								
AW								
Accept/Reject								

Measured by: JL **Date:** 10-11-19

Audited by: J.K. **Date:** 20/11/22

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
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E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	Mong DP	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					